Work Order I July-23-13 12:57:50			*104	<u> </u>				Page
Item ID: D30 Revision ID: Item Name: Space)24-1 per	A	Accept	*พฺจกกก∠	เกากต)* s	Setup Start	14.71
Start Date: 7/23 Required Date: 7/23 Reference:		*24* *24*		Cust Item ID: Customer:				
	ocess Plan: <u>ル</u> して	Date: 13-07-25	Tooling: SPC (Y/N):	Date:		R	tun Start Stop	"NR1"
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID To	ol# Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Revision Nbr							
D3024	Rev A			1		· ·		·
00 * 1	Hardinge CNC LATHE S Memo Turn blank a	MALL s per Folio FA267 and Dwg	0.00 AS 0.00 AO D3024 9-89	13/08/01	••	_24_	_Ø	
*110 *110* QC Quality Control	QC2- Inspect parts off ma	achine FAI/FAIB	0.00 QQ Q	13/08/01		24_	<u>Ø</u>	
* 120 * 120 * Small Fab Small Fab	Small Fab Memo Deburr		0.00 - A 0.00 - 3-6			24	Ø	

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-O	ONFOR	MANCE / UP		QA Closed:	Date:	
Work Ordo	Work Order:				DISPOSITION		-	AGAINST DE	PARTMENT,	/PROCESS	
Part No.			Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing				Water Jet d. Eng. Coor.	Engineering Quality Other			
NCR N	lo				Use-as-is Work Order Update	i nem	Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		· · · · - · - · - · · - ·
Cause	Date	Step	Qty	C	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data					·						
Equip/Tooling											
Operator	<u>. </u>										
Material											
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Other											
Process							1				
Supplier		İ							,]	
Training ['									
Unapproved		<u>L</u>									
		-			F	AULT CATE	GORY				

Mislabeled Positioned Wrong Heat Treat Countersink Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Drill Holes Ripples in Bend Offset Out of Calibration Drawing Torque Waves in Extrusion Finish Out of Sequence Turning Sequence Wave/Twist in Tube Folio Outside Dimensions

Grain

Hardware

Maintenance

Inspection Incomplete

Instructions Incomplete/Unclear

Pressure/Forced

Weld

Temperature/Cure

Wrong Stock Pulled

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Over/Under tolerance

General

Bend

Burrs

BOM/Route

Contamination

Broken/Damaged

Landing Gear

Bending

Cracks

Cuffs

Crushed/Crimped

Centre Not Concentric to O/S

Work Order ID 104966 July-23-13 12:57:50 PM	*104	966*	Page 2
Item ID: D3024-1 Revision ID: Item Name: Spacer Start Date: 7/23/13 Start Qty: 24.00 *24* Required Date: 7/23/13 Req'd Qty: 24.00 *24* Reference:		*N900040100 Cust Item ID: Customer:)* Setup Start *NS1* Stop *NS2*
Approvals: Process Plan: Date: QC: Date:		Date:	Run Start *NR1*
Sequence ID/ Work Center ID 130 QC8- inspect parts - second check *130* QC Quality Control	Set Up/ Run Hours 0.00	Tool ID Tool # Plan Code	Accept Reject Reject Insp. Qty Qty Number Stamp
140 Identify as per dwg & Stock Location: <u>\$\frac{5\triangle}{2}\rightarrow *1\Lambda\triang** Packaging Memo Packaging</u>	4 0.00 0.00		24xM.D. 13-08-
QC21- Final Inspection - Work Order Release *150* QC Memo Quality Control	0.00		MLJ 13-08-09

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QA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

recit.	cs / 110				Work onder Norv				QA Closed:	Dat	e:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	· ·
Part N					Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality		
NCR No. Use-as-is Work Order Update] The	ermoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other			
Root				Descri	ption of work order update	Initia	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data											
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	•				F	AULT CA	TEGORY				
Landin	ng Gear			<u></u>	General			_	7	r -	
L	Bending				Bend	Grai	n	<u> </u>	Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspi	ection Incomplete		Part Incorre	ct '	Weld
	Crushed/	Crimped		i	Burrs	Instr	uctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
ĺ	Cuffs				Contamination	Mai	ntenance		Part Moved		
	Heat Trea	at '			Countersink	Misl	abeled	<u>L</u>	Positioned \	Wrong _	_
	Inspectio	n Strip in	Tube		Cut Too Short	Misr	ead	L	Power Loss/	/Surge	Other
[Ripples in	n Bend			Drill Holes	Offse	et .				
	Torque V	Vaves in E	Extrusion	n [Drawing	Out	of Calibration				
	Turning S	equence			Finish	Out	of Sequence				<u>.</u>
	Wave/Tw	vist in Tul	be	[Folio	Outs	ide Dimensions				

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Picklist Print July-23-13 12:57:5													Palge
Work Order ID:	104966 D3024-1						, <u></u> · · ·		art Date: 7/23/1	3	Required D		
Parent Item Name:	Spacer						ı	St	tart Qty: 24.00		Required	Qty: 24.00	3 1
Comments:		eformat; Made or					<u>!</u>						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.375 303 Round Bar 0.375"		Purchased	No		•	100	f	22.0600	0.0729	1.8416	832 OAS 40 9-89	13/08	10V
				<u>Location</u>		Loc Oty	Lo	c Code			9-89		1
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											DQA:	Date:		
NCR: Y	'es	/ No				WORK ORDER NON-O	O	NFORI	MANCE / UPDATE		QA Closed:	Date:	,	
Work Orde	b Order: DISPOSITION							AGAINST DEPARTMENT/PROCESS						
Part No			Rework Scrap Use-as-is Work Order Update Skid-tube Crosstube Machining Machining Small Fab Thermoforming Large Fab Composite			-₹	Water Jet J. Eng. Coor. e/Packaging Supplier	Engineering Quality Other						
Root					Descri	ption of work order update		Initial	Action		Sign &	_		
Cause		Date '	Step	Qty	,	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							AUI	T CATE	GORY				.	
Landir	_					General	_	1		Γ-	7	_	٠. ،	
		Cracks	ending Bend entre Not Concentric to O/S racks Broken/Damaged Burrs				4	ion Incomplete ions Incomplete/Unclear		Ovalized Over/Under Part Incorrec Part Lost/Mis	ıt	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled		
	\vdash	Heat Trea	it			Countersink		Mislabe			Positioned W	/rong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short Drill Holes

Drawing

Finish Folio

DART AEROSPACE LTD	Work Order:	104966
Description: Spacer	Part Number:	D3024-1
Inspection Dwg: D3024 Rev: A		Page 1 of 1

	FIRS	T ARTICLE	INSPEC	TION CH	IECKLIST		
		X First Ar	ticle	Pro	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
0.750	+/-0.010	.749			VERN	PHO-12	
Ø0.313	+0.005/-0.000	.3146			Mic	PHD-0	2
Ø0.191	+0.010/-0.000	. 194			JERN	P40-12	
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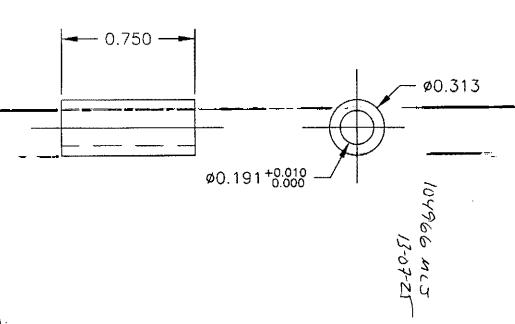
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DESIGN (A)	DRAWN BY		SPACE LTD DITARIO, CANADA
CHECKED	APPROVED	D3024	REV. A SHEET 1 OF 1
DATE		TITLE	SCALE
01.05.18		SPACER	2:1
A	01.05.18	NEW ISSUE	



THIS PART CAN BE PROCURED AS FINISHED PART UNDER NAS43HT3-48 OR MANUFACTURED FROM D2835.

2) MATERIAL: AISI 303/304/316/416 STAINLESS STEEL BAR. 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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